



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G26631-3G

Job Sheet 192470



Part No: RBW6305G26631-3G

Job Qty: 2 pcs

Part Name: Main Gear Box Alignment Pins



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/26/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6305G26631-3G Rev. 2 IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Small Fab - Issue SN	2 pcs	4/19/19		0.00	0.00	Small Fab - 1		MLL
							Small Fab - 3		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	2 pcs	4/19/19		0.00	2.00	External Load - 1		MLL
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
120	QC 5	2 pcs	4/19/19		0.00	0.00	QC 4 - 28		DAS 40 9-89
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	2 pcs	4/19/19		0.00	0.00	Packaging 3 - 1 - B4B		JUN 1 0 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S188702



Part: RBW6305G26631-3G

Job No: 192470

Serial No/Batch: S188702

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/10/19

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					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/19/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

RB001

Dart M.

DAS

21 JUN 1 0 2019

Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into
 Descriptions: Pelican case APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue
 placard RBW6305G26631-3G-5 to RBW6305G26631-3G-9 foam as per DWG. 6-Glue foam to case and pack case as per
 DWG.

120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	5163934
APP-1400-E	Case	1 Ea (1 ea)	110-Small Fab - 1	5171644
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	3021040
85 RBW6305G26631-3G-1	Pin	4 pcs (4 ea)	110-Small Fab - 1	5185563
96 RBW6305G26631-3G-3	Handle	4 pcs (4 ea)	110-Small Fab - 1	5185564
91 RBW6305G26631-3G-5	Placard	1 pcs (1 ea)	110-Small Fab - 1	5154917
RBW6305G26631-3G-7	Bottom Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5171636
RBW6305G26631-3G-9	Top Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5171641

128B

1

138A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	4	401	0
	APP-1400-E	1	9	0
	RB41011	1	369	0
	RBW6305G26631-3G-1 - PO	4	0	0
	RBW6305G26631-3G-3 - PO	4	1	0
	RBW6305G26631-3G-5	1	4	0
	RBW6305G26631-3G-7	1	2	0
	RBW6305G26631-3G-9	1	2	0

010251

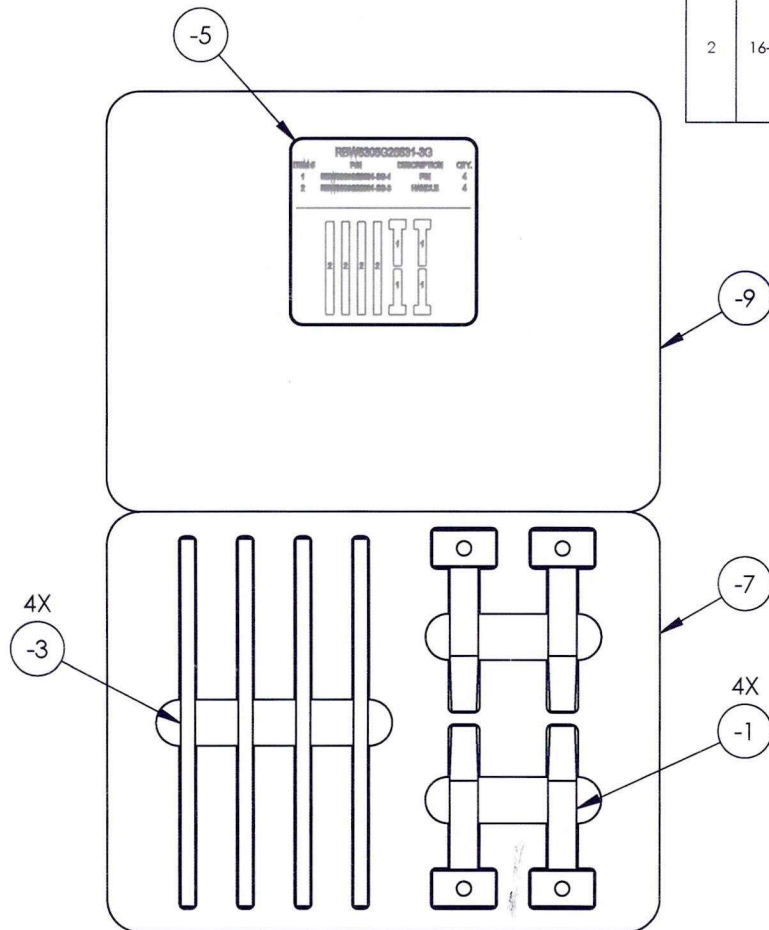
Part Specifications

Specifications could not be found.

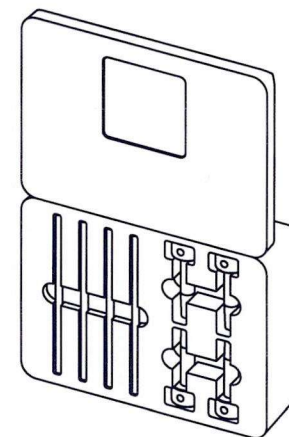
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0156	CH'D TITLEBLOCK WAS RED BARN IS DART. -5 CH'D PART #'S ON CARD WAS RBW6305G26631-3 IS RBW6305G2661-3G-1, WAS RBW6305G26631-3 IS RBW6305G26631-3G-3.	9/19/2014	DJN	RJC
2	16-0132	-1 CH'D DIM WAS (Ø1.375) IS Ø1.38, WAS 3.935 IS 3.94, WAS (.83) IS .83, WAS Ø.313 S.F. -3 THRU ALL IS Ø.3168/.3150 THRU ALL (S.F. -3), ADDED DIM 2X .03 X 45°. -3 CH'D DIM WAS (Ø.313) IS .31 (S.F. -1), CH'D FINISH WAS BLACK ANODIZE, IS BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D. CH'D MATERIAL WAS 1018 IS 1018/1020 CR. -5, -7, -9 CH'D DWG. TO SHEET METAL TOLERANCES. -5 DELETED TEXT HT. NOTES, CH'D DIM WAS (.06) IS .06 ADDED NOTE USE PDF. -7, -9 CH'D MATERIAL & VENDOR WAS Y20 BLACK, I.R. SPECIALTIES IS ETHAFOAM 220 BLACK, (CASE SOLUTIONS). -7 DELETED DIM'S 4X .37, 4X 1.44, 4X 3.15, 4X .68, 4X .85, 4X R.72, ADDED DIM'S 6X R.50, 4X .75, 4X 45°, CH'D DIM WAS 3.95 IS 3.92, WAS .37 IS .34. -9 DELETED DIM 4X R.45, ADDED DIM'S 4X .45, 4X 45°, 1.00, CH'D DIM'S WAS 4.03 IS 4.06, WAS 1.20 IS 1.17.	11/10/2016	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192470415
1903-26



NOTE:
REF. AGUSTA T/N: 3G6305G26631.

			
TITLE			
MGB ALIGNMENT PINS			
DWG NO.			REV
RBW6305G26631-3G			2
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:		1. BREAK ALL SHARP EDGES	
MARPET		.015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY	
MACKOVJAK		AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER	
ANDERSON		ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
LINDSAY		AW139	
APPROVED:			
GILBERT			
SCALE		DATE	SHEET 1 OF 6
1:4		5/30/2013	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	4	PIN	BRASS		2
			-3	4	HANDLE	1018/1020 CR	(MCMaster-CARR #8920K265) MODIFIED	3
			-5	1	PLACARD	PLASTIC		4
		B/O	-7	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	3.92 X 9.08 X 11.98 (CASE SOLUTIONS)	5
		B/O	-9	1	TOP FOAM	ETHAFOAM 220, BLACK	1.17 X 9.08 X 11.98 (CASE SOLUTIONS)	6
		B/O	-11	1	CASE	PLASTIC, BLACK	PELICAN #APP-1400-E	N/S
		B/O		1	PLACARD	ALUMINUM	RB41011	N/S

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					